

Date: Wednesday, 7/12/2006 3:23:51 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT
Job Number : 27874
Estimate Number : 12487
P.O. Number : N/A Part Number : D35021
This Issue : 7/12/2006 S.O. No. : N/A Drawing Number : D3502 PREL
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : PREL
Previous Run : N/A Material : N/A
Written By : Due Date : 7/30/2006 Qty: 16 Um: Each
Checked & Approved By :
Comment : Est Rev:A New Issue 06-07-06 JLM
Note: Estimate is currently made for manual machining .(temp only)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R325 6061-T6 Round Bar 3.25"



Comment: Qty.: 0.0893 f(s)/Unit Total: 1.4280 f(s)
6061-T6 Round Bar 3.25" 3.5"
(M6061T6R325)
Batch: M100720

06/09/19

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
Turn as pwer Dwg D3502

06/09/21 / 16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/09/21 / 16

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Mill as per Dwg D3502

Drilled .098 Hole

FF 06-09-25 16

06/09/22 / 16

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/09/22 / 16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06.09.25	7	Acceptable to drill $\varnothing 0.098$ tooling hole 0.175" from edge as per marked-up drawing. See attached P.S. email Add to Drawg: Estimate. <i>J. Permechance</i>				UP 06.09.25 PR Q510472	2 06.09.25	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ~~QA~~ Date: 06/09/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 27874

Part Number: D35021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/09/22 x 16

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 09 26 (16)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Y.L. 06-09-26 (16)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/9/27 16

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

57446 06/8/27 (16)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/07 (16)

Job Completion



06.09.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

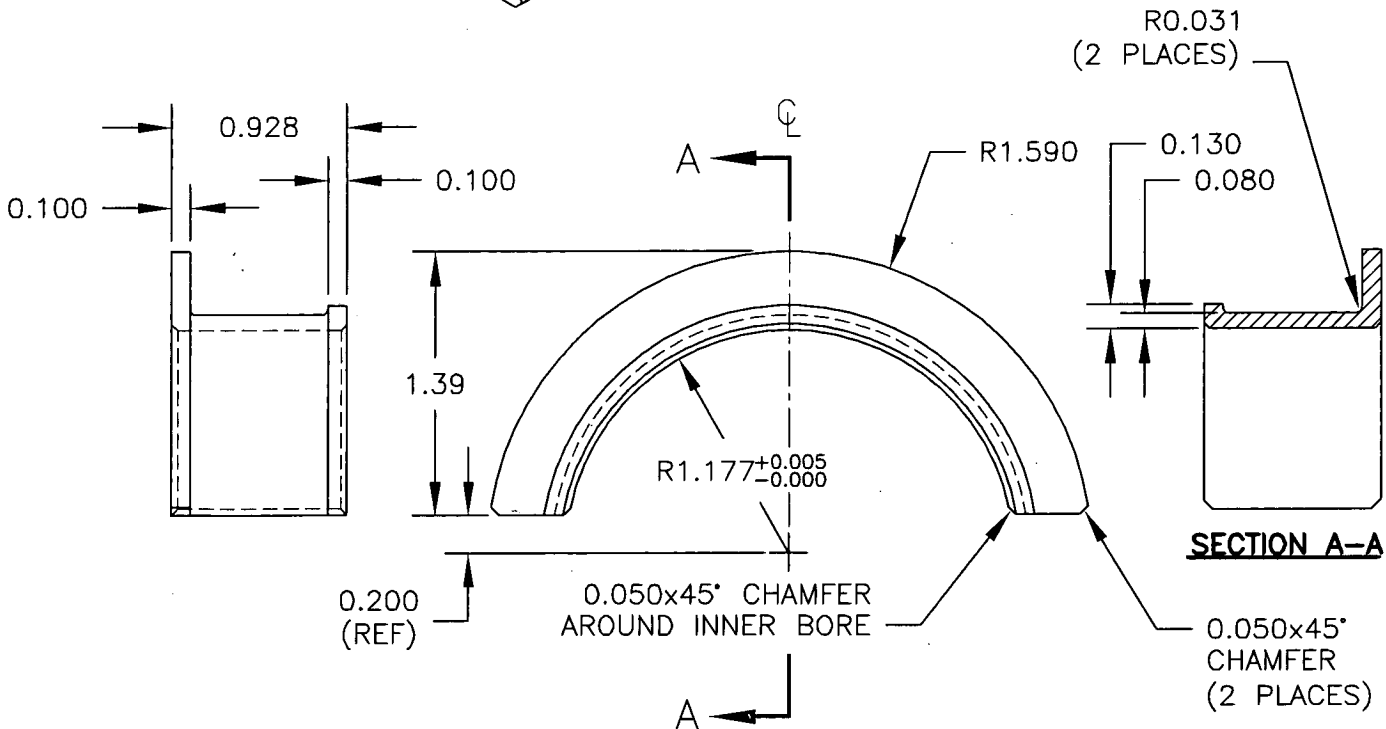
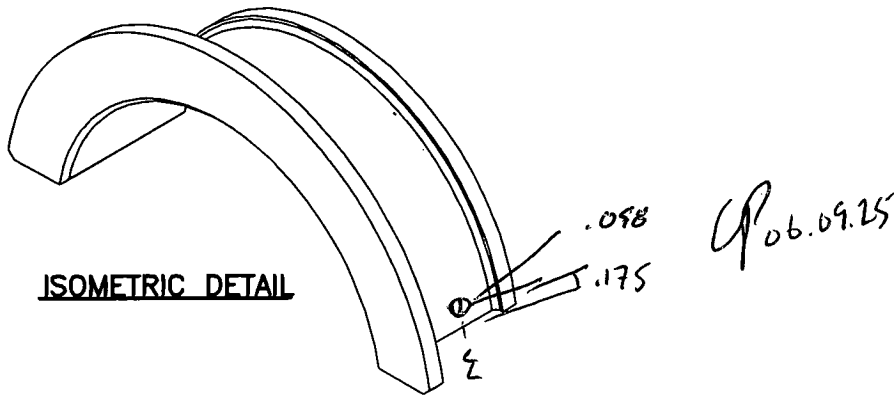
QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

UNDER REVIEW

06.10.12 *qp*

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3502	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = \pm 0.010, X.XX = \pm 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27874

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x | Prototype

Comments

Date:

New Issue

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: September 25, 2006 11:45 AM
To: 'Chris Provencal'
Subject: RE: Deviation on D3502-1

This is acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Monday, September 25, 2006 8:59 AM
To: David Shepherd (David Shepherd)
Cc: 'S Shahbazian'
Subject: Deviation on D3502-1

David,

The D3502-1 Support for the 350 xtubes, there needs to be a 0.098 tooling hole to hand the part during finishing. I think you are already aware of this, we needed to do this to the preliminary parts. The drawing will be updated to add the optional tooling hole (when we update the xtube drawings for the finish), in the meantime we need permission for the hole.

Chris

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No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.405 / Virus Database: 268.12.6/453 - Release Date: 9/20/2006

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.405 / Virus Database: 268.12.6/453 - Release Date: 9/20/2006

25/09/2006